Date: Monday, 11/6/2006 1:32:12 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		**Drawing Name**	: 350 SKIDTUBE ASSEMBLY RH
Job Number	: 29293			
Estimate Number	: 10265			
P.O. Number	: N/A		**Part Number**	: D350636012
This Issue	: 11/6/2006	**S.O. No.** : N/A	**Drawing Number**	: D2750
Prsht Rev.	: NC		**Project Number**	: N/A
First Issue	: N/A	**Type** : LANDING GEAR	**Drawing Revision**	: D
Previous Run	: 29037		**Material**	: NA
Written By	:		**Due Date**	: 11/30/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	: 06 11 06			

Comment : Est Rev:I 02.09.25 Rearranged procedure steps KJ
Est Rev:J 06-03-29 As per Rev D EC
Est Rev:J 06-07.13 As per dsi9343 EC

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy blue file and type labels per PPP D350-636-012 CHG 002 KJ 06.11.06

2.0	D26003BENT	Extrusion Bent

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2600-3-Bent	Extrusion (Bent)	B26787 PM 06-11-20 (1)

3.0	D2744	Fwd Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cap
Batch: B-27559 BE 06-12-06

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end PM 06-11-20 (1)

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8863 drilling holes labelled "A" only. PM 06-11-20 (1)

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750. PM 06-11-20 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** ________ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 350 SKIDTUBE ASSEMBLY RH

Job Number: 29293 **Part Number:** D350636012

Job Number:

Seq. #:	Machine Or Operation:	Description :

4-Drill pilot holes for Detail B using DT8330 Pm' 06-11-20 ①

5-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750 . Pm' 06-11-20 ①

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" ***Make sure that wearplate holes are on bottom of tube****** Pm' 06-11-20 ①

7-Open up holes of Detail A to 0.250" (total of 2 holes per side) Pm' 06-11-20 ①

8- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750. Pm' 06-11-20 ①

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod M101446 BE 06-12-06

10-Grind welds flush as per Dwg D2750 BE 06-12-13

11-Countersink Detail A as per dwg D2750. BE 06-12-13

Seq. #:	Machine Or Operation:	Description :
5.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION M 06/12/18 ①

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP M 06/12/18 ①

Seq. #:	Machine Or Operation:	Description :
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Pm' 06-12-19 ①

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Seq. #:	Machine Or Operation:	Description :
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION RT 06-12-19

Seq. #:	Machine Or Operation:	Description :
9.0	D2739	350 I Beam

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Web Batch: 29341 Pm JD 06-12-19 ①

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 1:32:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 29293
Part Number: D350636012

Job Number:

Seq. #:	Machine Or Operation:	Description :
10.0	D34901	CROSS BOLT SPACER

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Crossbolt spacer
Batch: B28874 BE 06-12-20

Seq. #:	Machine Or Operation:	Description :
11.0	D34903	CROSS BOLT SPACER

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Crossbolt spacer
Batch: B29016 BE 06-12-20

Seq. #:	Machine Or Operation:	Description :
12.0	D2743	Crossbolt Spacer

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Crossbolt Spacer
Batch: B27741 BE 06-12-20

Seq. #:	Machine Or Operation:	Description :
13.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750. PM 06-12-19 (1)

2-Open up holes of Detail D to 0.750" (total of 4 holes per side) as per dwg D2750. PM 06-12-19 (1)

3-Chamfer holes of Detail V, Detail C, Detail D and hole size "W" per dwg D2750 (welding instructions on sheet 4) PM 06-12-19 (1)

4-Deburr and blow out all chips from inside of tube PM 06-12-19 (1)

5-Bond web D2739 in place as per QSI 015
A/R Sikaflex-291 batch: M 102672 JT/JD 06-12-19 (1)
exp. date: 07-02-01

7- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 4)
A/R Aluminum Rod batch: M 101446 BE 06-12-20

8-Grind welds flush as per Dwg D2750 PM 06-12-20 (1)

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 1:32:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 29293
Part Number: D350636012

Job Number:

Seq. #:	Machine Or Operation:	Description :
	9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750 Pm 06-12-20 (1)	
	10-Deburr holes Pm 06-12-20 (1)	
14.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	06/12/21 (1)
15.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	06/12/21 (1)
16.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	06/12/28 (1)
17.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION Inspect for foreign object per QSI 024	07-01-05 (1)
18.0	NAS1330S3KB166	INSERT
	Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s) INSERT Batch B102644	a.m 07/01/05 (1)
19.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 1-Install inserts as per dwg D2750	a.m 07/01/05 (1)
20.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP Inspect Inserts	07.01.05 (1)

Form: rprocess

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Monday, 11/6/2006 1:32:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 29293
Part Number: D350636012

Job Number:

Seq. #:	Machine Or Operation:	Description :
21.0	D26483	Wearpad

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Wearpad
Batch: 29038

Seq. #:	Machine Or Operation:	Description :
22.0	D265613	Wearplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate
Batch: 27739

Seq. #:	Machine Or Operation:	Description :
23.0	D265635	Wearplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate
Batch: 26206

Seq. #:	Machine Or Operation:	Description :
24.0	D2746	Wearshoe

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate
Batch: 28257

Seq. #:	Machine Or Operation:	Description :
25.0	D2745	Bushing

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bushing
Batch: 28974

Seq. #:	Machine Or Operation:	Description :
26.0	D3488042	BLADE FITTING ASSEMBLY, RH

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Blade Fitting, LH
Batch: 28319

JK 07/01/10

Form: rprocess

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 1:32:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 29293
Part Number: D350636012

Job Number:

Seq. #:	Machine Or Operation:	Description :
27.0	D3492041	PLUG ASSEMBLY

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
PLUG ASSEMBLY
Batch: 28960

Seq. #:	Machine Or Operation:	Description :
28.0	D3492043	PLUG ASSEMBLY

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
PLUG ASSEMBLY
Batch: 29045 #6 28560 29024 #2

Seq. #:	Machine Or Operation:	Description :
29.0	AN3C5A	Bolt

Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)
Bolt
Batch: 102536

Seq. #:	Machine Or Operation:	Description :
30.0	AN3C6A	BOLT

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: 19522 ✓

Seq. #:	Machine Or Operation:	Description :
31.0	AN3C7A	BOLT

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT
Batch: 102254

Seq. #:	Machine Or Operation:	Description :
32.0	AN6C44A	BOLT

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT
Batch: 102410

Seq. #:	Machine Or Operation:	Description :
33.0	AN8C35A	BOLT

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT
Batch: 102180 Yl 07/01/10

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 1:32:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 29293

Part Number: D350636012

Job Number:

Seq. #:	Machine Or Operation:	Description :
34.0	AN960C10L	washer

Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)
washer
Batch: 102079

Seq. #:	Machine Or Operation:	Description :
35.0	AN960C816L	WASHER

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER
Batch: 100186

Seq. #:	Machine Or Operation:	Description :
36.0	MS210436	NUT

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
NUT
Batch: 102532

Seq. #:	Machine Or Operation:	Description :
37.0	MS21083C8	NUT

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
NUT
Batch: 100186

Seq. #:	Machine Or Operation:	Description :
38.0	NAS1515H3L	WASHER

Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)
WASHER
Batch: 102039

Seq. #:	Machine Or Operation:	Description :
39.0	NAS1515H8L	WASHER

Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
WASHER
Batch: 102535

YL ~~07/01~~ 07/01/10

Seq. #:	Machine Or Operation:	Description :
40.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"
batch: 101915

YL 07/01/10

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

29954

Date: Monday, 11/6/2006 1:32:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 29293
Part Number: D350636012

Job Number:

Seq. #:	Machine Or Operation:	Description :

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241
BATCH: 102672
EXP DATE: 02/07

4-Coat all exposed fasteners with "LPS Procyon"
batch: 17168

JL 07/01/10

Seq. #:	Machine Or Operation:	Description :
41.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP — FC 07 01 120

Seq. #:	Machine Or Operation:	Description :
42.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

Seq. #:	Machine Or Operation:	Description :
43.0	D2741	Blade

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Blade
Batch: b28521

Seq. #:	Machine Or Operation:	Description :
44.0	AN960C816L	WASHER

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: M100186

Seq. #:	Machine Or Operation:	Description :
45.0	MS21083C8	NUT

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
Batch: M100186

Seq. #:	Machine Or Operation:	Description :
46.0	AN8C21A	BOLT

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M102473

07/01/10

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______ **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/01/17

QA: N/C Closed: _____ **Date:** ______

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 1:32:13 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 29293

Part Number: D350636012

Job Number:

Seq. #:	Machine Or Operation:	Description :
47.0	NAS1515H8L	WASHER
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) WASHER Batch: M102515 ✓	
48.0	D34931	WASHER
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) WASHER 627835 ✓	
49.0	D35321	spacer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) spacer 627894 ✓ 04/01/16	
50.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
	Comment: INSPECT 100% KITS FOR COMPLETENESS 07/01/16 (1)	
51.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Package as per PPP D350-636-012 04/01/16 NUR 07/01/16	
52.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE (1) 07/01/17	

Job Completion C 07/01/17

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
PH	PH	
CHECKED	APPROVED	DRAWING NO. D2750 — REV. D — SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS

REV	DATE	DESCRIPTION
A	98.04.16	NEW ISSUE
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157

RELEASED 06.02.07

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29293

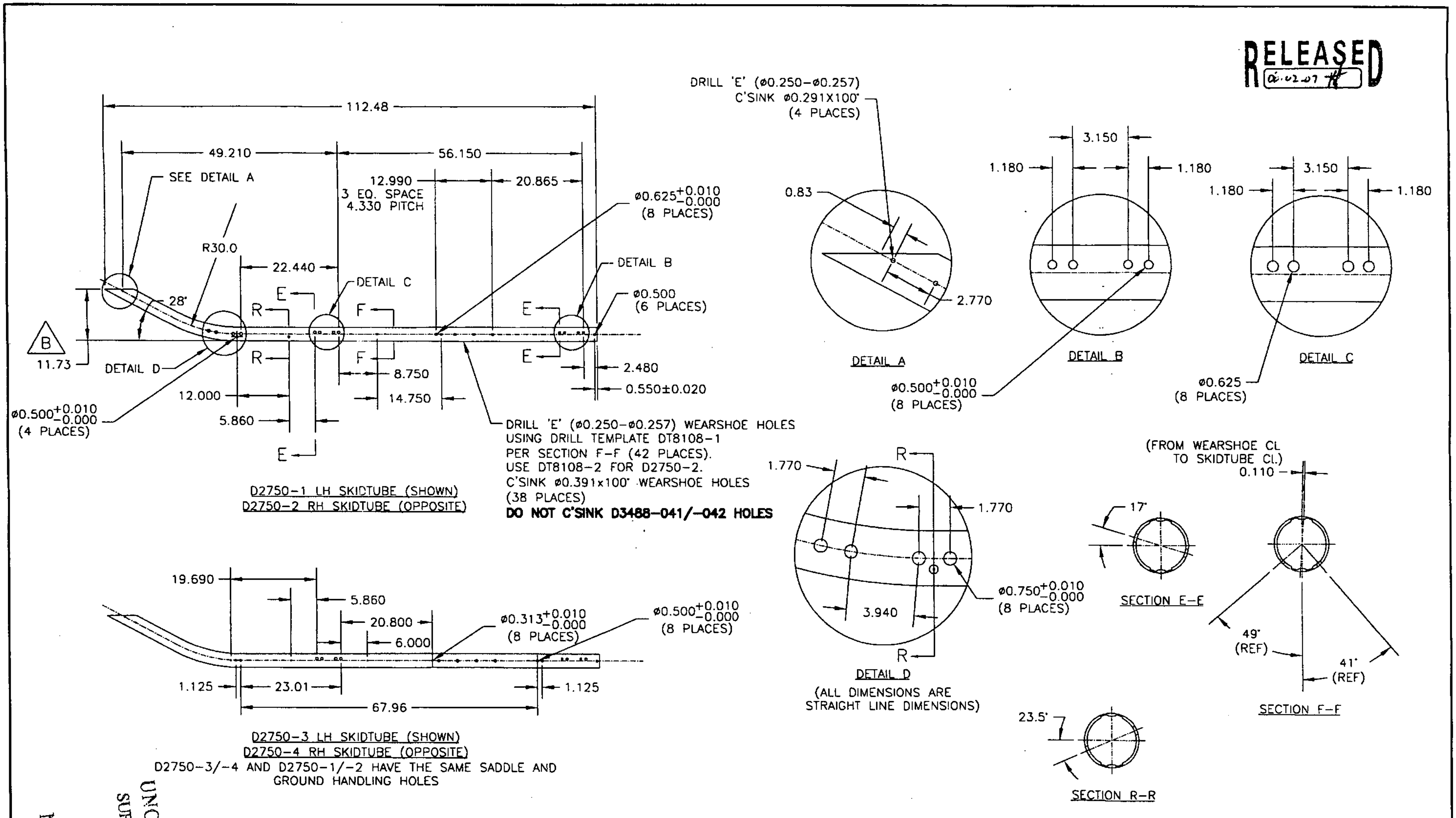
DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2750 — REV. D — SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS

DART

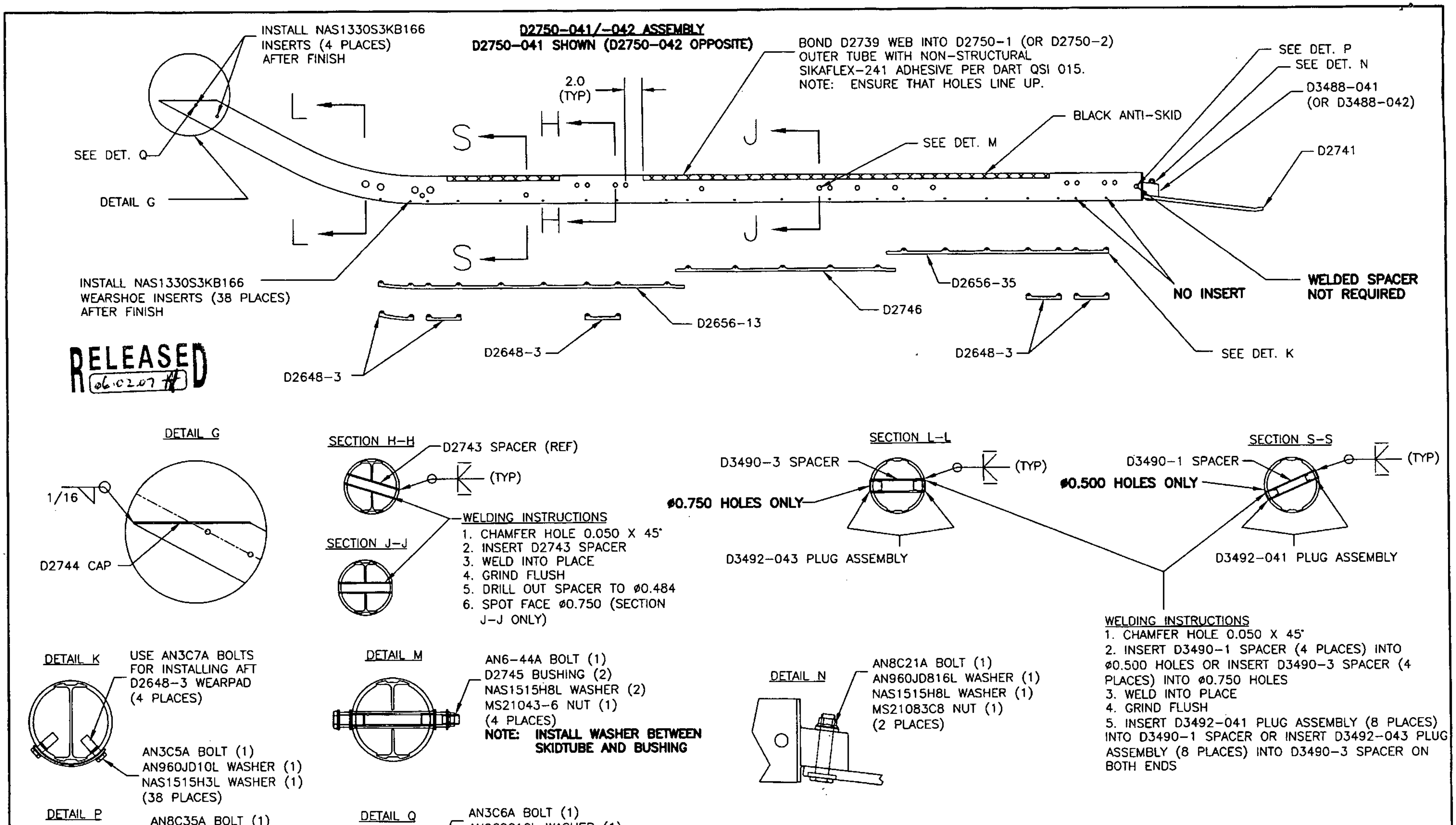
RELEASED 06.02.07

GENERAL NOTES:

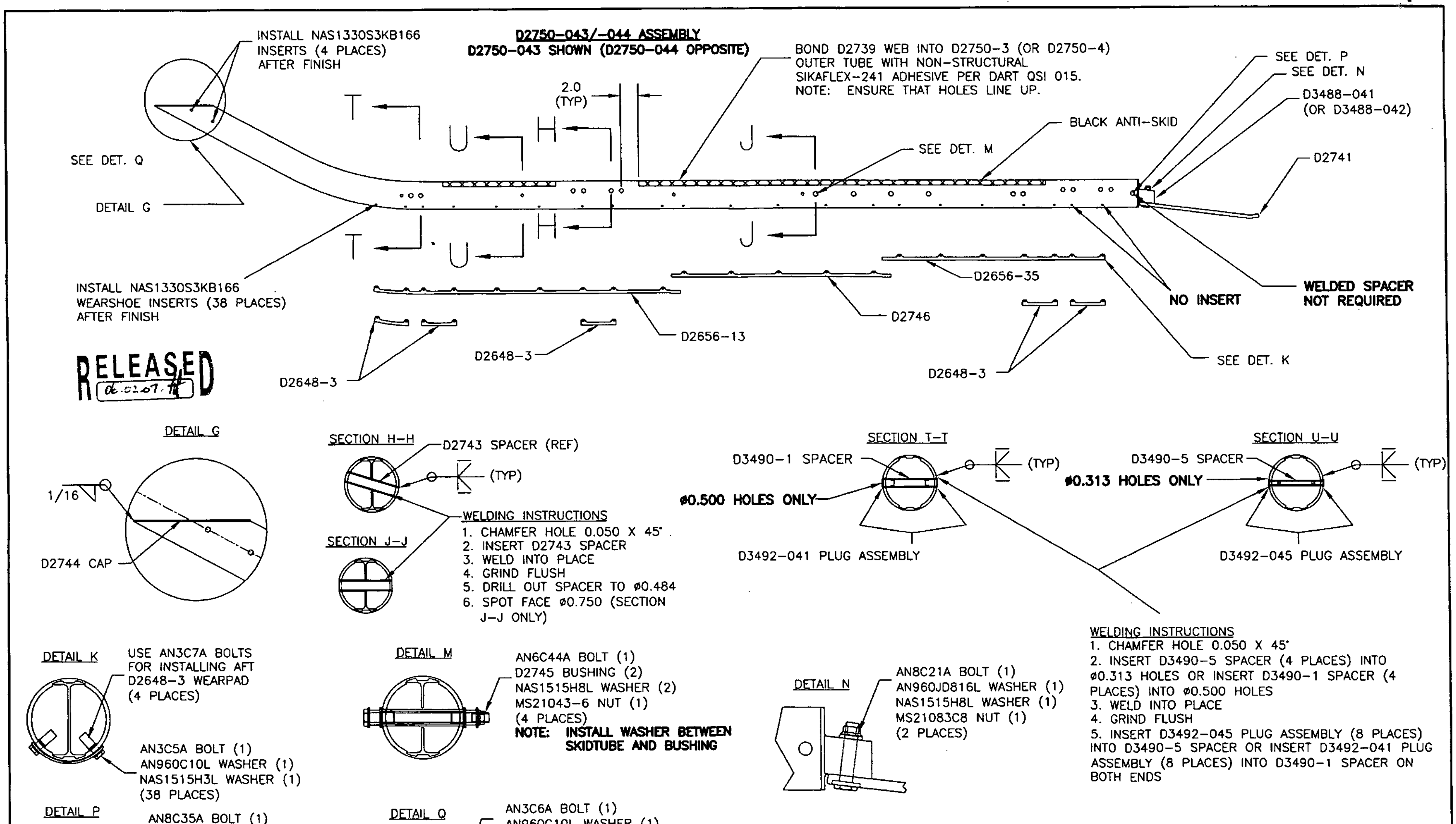
1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
   THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
   MINIMUM YIELD TENSILE STRENGTH = 35 ksi
   MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
   ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
   POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES (Ø0.250- Ø0.257) FOR WEARSHOE INSERTS. C'SINK Ø0.391 X 100° AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX –241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES



DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
PH	PH	DRAWING NO. D2750 — REV. D — SHEET 3 OF 5
CHECKED	APPROVED	TITLE: 350 SKIDTUBE ASSEMBLY
DATE 06.01.05		SCALE 1:20



DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
PH	PH		
CHECKED	APPROVED	DRAWING NO. D2750	REV. D SHEET 4 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20



DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
PH	PH	
CHECKED	APPROVED	DRAWING NO. D2750 — REV. D — SHEET 5 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY — SCALE 1:20

NO. 79

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A350 636011 / B29429

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete [ ] Partial [✓] Single Weld [✓] Double Weld [ ]
Current AC [✓] DC [ ] Backing YES [ ] NO [✓]

Position			Vertical Down [ ]	Up [ ]
Sheet Groove	1G [ ]	2G [ ]	3G [ ]	4G [ ]
Tube Groove	1G [ ]	2G [ ]	5G [ ]	6G [ ]
Sheet Fillet	1F [ ]	2F [ ]	3F [ ]	4F [ ]
Tube Fillet	1F [ ]	2F [ ]	4F [ ]	5F [ ]

N/A

Crossbolt Spacer Welded into ____________ Skidtube

TEST RESULTS

Visual Pass [✓] Fail [ ]
Penetration Pass [✓] Fail [ ]

Crossbolt Spacer Pass [✓] Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/11/28 Qualifier [signature]